

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025521**Date Inspected:** 08-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

**Bay Number 1**

Performed verification VT for the component(s) identified as OBG Barrier Rails for component(s) listed as E2-SB1D-037, E2-SB1D-034, E2SB1D-036, E2-SB5-027, E2-SB5-028, E2-SB5-019, E2-SB5-032, E2-SB2D-001, E2-SB1-027, E2-SB1-042, & E2-SB1-054. This QA inspector signed green tag #15408.

**Bay Number 2**

Performed verification VT for the component(s) identified as OBG Sub Assembly for component(s) listed as SA3451-001. This QA inspector signed green tag #15402.

Performed verification VT for the component(s) identified as OBG Sub Assembly for component(s) listed as SA3416-001. This QA inspector signed green tag #15416.

Performed verification VT for the component(s) identified as OBG Sub Assembly for component(s) listed as SA3131-001. This QA inspector signed green tag #15414.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Performed verification VT for the component(s) identified as OBG Sub Assembly for component(s) listed as SP3145-001. This QA inspector signed green tag #15415.

FCAW welding of complete joint penetration welds located on Floor Beam component identified as FB3343-001 for weld no. 347. Welder is identified as welder no. 067876. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of buttering welds located on Sub Assembly component identified as SA34446-001 as identified on critical weld repair data sheet B-CWR-2371 for plate no. X5074J. Welder is identified as welder no. 045209. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-FCAW-ESAB-REPAIR-FCM.

SMAW welding of complete joint penetration welds located on Longitudinal Diaphragm component identified as LD3048-001 as identified on weld repair data sheet B-WR-18352 for weld no. 050. Welder is identified as welder no. 066763. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-3G(3F)-repair.

FCAW welding of complete joint penetration welds located on Floor Beam component identified as FB3343-001 for weld no. 346. Welder is identified as welder no. 067876. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration welds located on Longitudinal Diaphragm component identified as LD3049-001 as identified on weld repair data sheet B-WR-16808 for weld no. 089, 117, 133, & 145. Welder is identified as welder no. 045276. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration welds located on Longitudinal Diaphragm component identified as LD3049-001 as identified on weld repair data sheet B-WR-16808 for weld no. 157, 169, 181, 193, & 105. Welder is identified as welder no. 045209. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

Bay Number 3

This inspector did not observe any welding or contract work in this bay today.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## Summary of Conversations:

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

---